

Date: Monday, 8/21/2006 2:10:53 PM
 User: Kim Johnston

Process Sheet

| | | | | | |
|-----------------------|-----------------------------------------------------------------------|------------------|--------------------------------|------|-------------|
| Customer | CU-DAR001 Dart Helicopters Services | Drawing Name | : LID PRO ARM ASSEMBLY (SHORT) | | |
| Job Number | : 28246 | Part Number | : D2332041 | | |
| Estimate Number | : 10258 | Drawing Number | : D2332 REV C1 | | |
| P.O. Number | : N/A | Project Number | : N/A | | |
| This Issue | : 8/21/2006 | S.O. No. | : N/A | | |
| Prsht Rev. | : NC | Drawing Revision | : C1 | | |
| First Issue | : N/A | Material | : N/A | | |
| Previous Run | : 27690 | Due Date | : 9/20/2006 | Qty: | 20 Um: Each |
| Written By | : <i>20 08 21</i> | | | | |
| Checked & Approved By | : <i>20 08 21</i> | | | | |
| Comment | : Est: B 02.08.12 Re-format; Incorporated D2332-13/-11/-7/-5KJ/ RF | | | | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : | |
|---------|-----------------------|-------------------------------------------------------------------------------------------------------------|------------------------------------------|
| 1.0 | M304TR1000WO49 | 304 RD Tube 1.0" x .049W | |
| | | Comment: Qty.: 0.4368 f(s)/Unit Total : 8.7360 f(s) Material: 1.000" OD x 0.049" wall SS Tube (Seamless) | Batch <i>M19448</i> <i>MF - 06/08/30</i> |
| 2.0 | M304R250 | 1/4" 304 SS Roundbar | |
| | | Comment: Qty.: 0.1092 f(s)/Unit Total : 2.1840 f(s) Material: Ø0.250" 304SS Rod | Batch <i>M17931</i> <i>MF. 06/08/29</i> |
| 3.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 | |
| | | Comment: SMALL & MEDIUM FAB RESOURCE 1 | |
| | | 1-Cut to length as per Dwg D2332 (D2332-7) Locking Collar | <i>MF. 06/08/31</i> <i>00</i> |
| | | 2-Cut to length as per Dwg D2332 (D2332-5) Stop Pin | <i>MF. 06/08/29</i> <i>00</i> |
| | | 3-Deburr | |
| 4.0 | M304TR0500W035 | 304 RD Tube .500 x .035W | |
| | | Comment: Qty.: 1.2080 f(s)/Unit Total : 24.1600 f(s) 304 RD Tube .500 x .035W | <i>M1593</i> <i>MF. 06/09/01</i> |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Design Mgr | Approval QC Inspector |
| | | | Initial Design Mgr | Action Description Design Mgr | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 8/21/2006 2:10:54 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LID PRO ARM ASSEMBLY (SHORT)

Job Number: 28246

Part Number: D2332041

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Punch or form to length as per Dwg D2332 (D2332-11) using DT8012

(Note: Make (2) D2332-11 Prop Arms per assembly.)

EB 06/09/01 (20)

6.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Drill hole in D2332-11 as per Dwg D2332 using Drill Jig DT8459. Deburr. (Drill 1 per assembly) MF. 06/09/01 (20)

2-Weld D2332-11 and D2332-5 as per Dwg D2332 using Welding Jig DT8298. (Weld 1 per assembly)

A/R SS Rod Batch: M100372

M06/09/07 (20)

7.0 QC5/9 WELD INSPECTION



Comment: WELD INSPECTION

PD 06.09.07 (20)

8.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Tumble

MF. 06/09/08. (20)

2-Assemble as per Dwg D2332

MF. 06/09/19. (20)

9.0 AN44A Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|---------|
| 1 | AN4-4A | Bolt | M100851 |

MF. 06/09/19

10.0 AN960JD416L Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|---------|
| 3 | AN960JD416L | Washer | M101231 |

MF. 06/09/19

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
| | | | | | | | |
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| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Design Mgr | Approval QC Inspector |
| | | | Initial Design Mgr | Action Description Design Mgr | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 06/09/20
 NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 8/21/2006 2:10:54 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LID PRO ARM ASSEMBLY (SHORT)

Job Number: 28246

Part Number: D2332041

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|------|-----------|-----|
| 11.0 | MS21042L4 | Nut |
|------|-----------|-----|



Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|---------|
| 1 | MS21042L4 | Nut (or -4) | MI 9085 |

mf - 06/09/19

| | | |
|------|-----|------------------------------|
| 12.0 | QC5 | INSPECT WORK TO CURRENT STEP |
|------|-----|------------------------------|



Comment: INSPECT WORK TO CURRENT STEP

FB 06/09/19

20

| | | |
|------|-------------|-----------------------|
| 13.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|------|-------------|-----------------------|



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST/69

10
23 06/09/20

20

| | | |
|------|----|------------------|
| 14.0 | DC | DOCUMENT CONTROL |
|------|----|------------------|



Comment: DOCUMENT CONTROL

Inspection Level 21

10 06/09/20

20

Job Completion



10 06/09/20

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

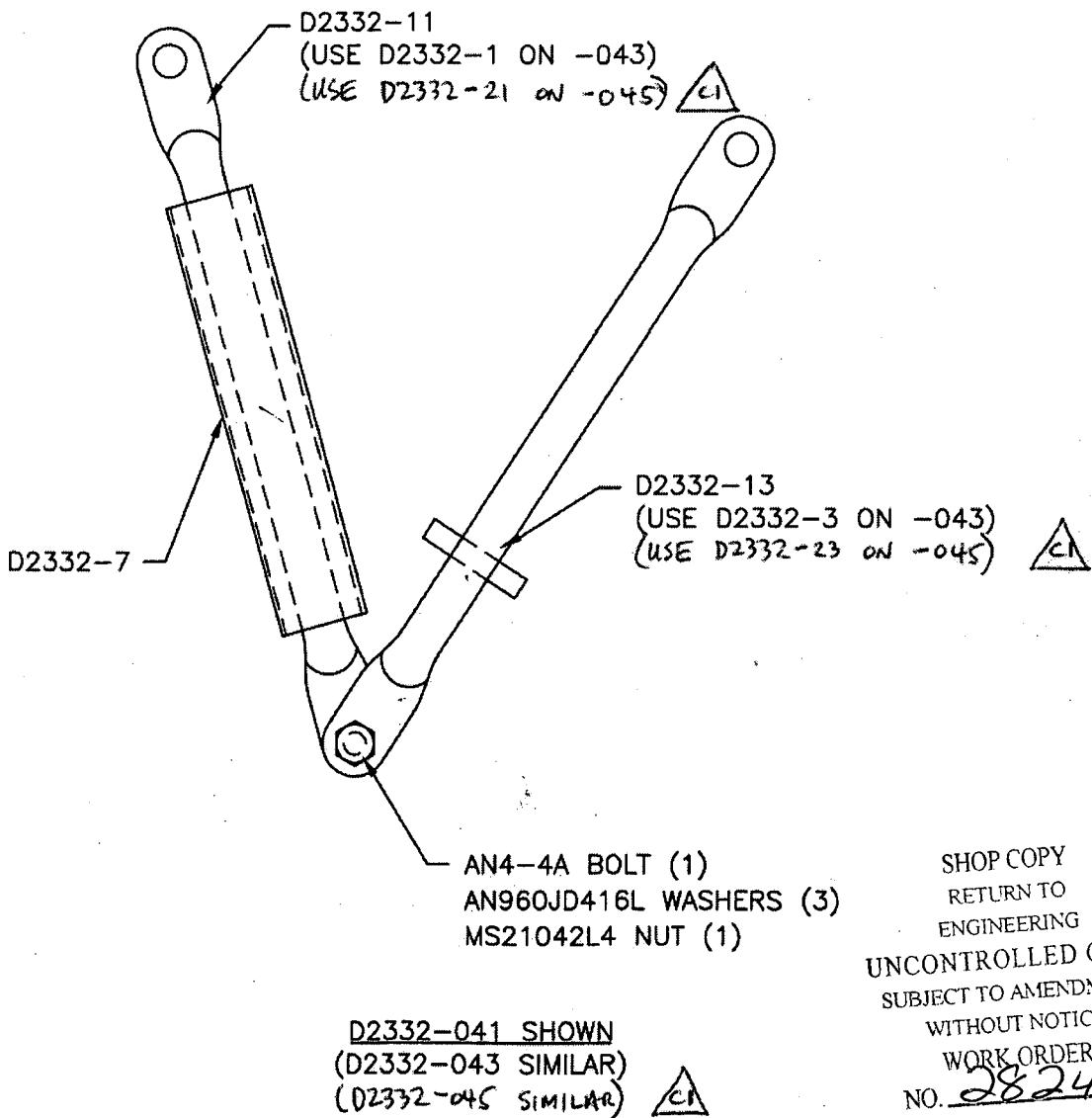
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Design Mgr | Approval QC Inspector |
| | | | Initial Design Mgr | Action Description Design Mgr | Sign & Date | | | |
| | | | | | | | | |
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| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

DART

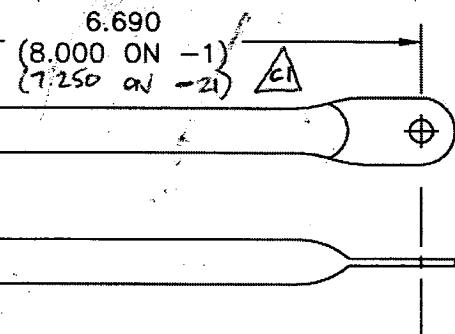
| | | | |
|----------|----------|---------------------------------------------------------------------|--------------|
| DESIGN | DRAWN BY | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | APPROVED | DRAWING NO. | REV. C |
| | | D2332 | SHEET 1 OF 2 |
| DATE | | TITLE | SCALE |
| 03.07.03 | | LOD PROP ASSEMBLY | NTS |
| A | 94.12.16 | NEW ISSUE | |
| B | 97.09.30 | CHANGE 416 WASHERS TO 416L | |
| C | 03.07.03 | MAKE -041 PROP 6.69" LONG (STD) MAKE -043 PROP 8.00" LONG (OPT.) | |
| C1 | 03.08.06 | ADD -045 PROP (7.25" LONG) | |

RELEASED
03.07.04

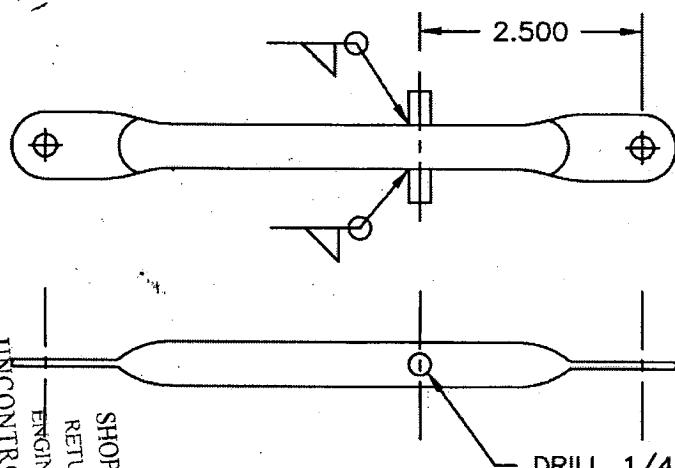
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RELEASED
03.07.04



D2332-11 PROP
(D2332-1 SIMILAR)

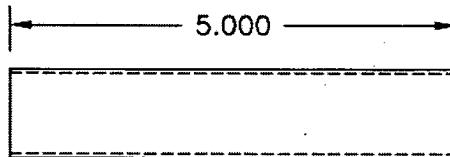


D2332-13
M/F D2332-11 & D2332-5

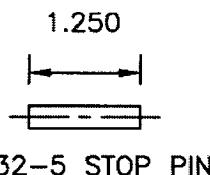
D2332-3 SIMILAR - M/F D2332-1 & D2332-5
(D2332-23 SIMILAR - M/F D2332-21 & D2332-5) C1

NOTES:

1. MATERIAL: 0.5 OD x 0.035 WALL SS TUBE (D2332-1/-11) M304TR0.500W.035
0.25 OD SS ROD 1.25 LONG (D2332-5) M303R0.250
1.0 OD x 0.049 WALL SS TUBE (D2332-7) M304TR1.000W.049
2. TUBE ENDS ARE CENTER-CENTER FOR D2332-1/-3 & D2332-11/-13



D2332-7 LOCKING COLLAR



D2332-5 STOP PIN

DART

copy
GACOPY
GACOPY

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA
REV. C
SHEET 2 OF 2

| DESIGN | DRAWN BY | DATE | TITLE | SCALE |
|--------------|--------------|----------|-----------------------------------------------------------------------------------------------------|-------|
| C | C | 03.07.03 | LID PROP ASSEMBLY | 1:12 |
| C1 | C | 03.08.06 | MALE -041 PROP 6.69" LONG (45mm) MALE -043 PROP 8.00" LONG (200mm) ADD -045 PROP (7.25" LONG) | |

NO. 26246

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